

Date: Thursday, 3/16/2006 10:37:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHROUD ASSEMBLY
Job Number : 26262	
Estimate Number : 12304	
P.O. Number : NIA	Part Number : D3467045
This Issue : 3/16/2006 S.O. No. : NIA	Drawing Number : D3467 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : NIA	Material : NIA
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06-03-16</u>	
Comment : Est Rev: A New Issue 06-03-01 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D346717	TOP COVER
-----	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-17	Shourd Plate	B26111

0603-30 ①

2.0	D34673	TUBE
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-3	Tube	

3.0	D346719	DOUBLER
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
<u>1</u>	D3467-19F	Doubler	B26112-1

0603-30 ①

4.0	D346720	doubler RH
-----	---------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-19F	Doubler	B26112-1

0603-30 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:37:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26262

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D346711

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-11	Bracket	

*fabricate by hand
as per dwg D3467-11*

0603-30 ①

M19704 CM3045266J 1'x1'

6.0

D34675

AFT PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-5	aft plate	B26108-1

0603-30 ①

7.0

D3467049

BAFFLE & DEFLECTOR ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-49	Baffle ass'y	B26463

0603-30 ①

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-045

0603-30 ①

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

10.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O:

Electro Chemically Polish weldment as per Dwg Dwg D3467

Ensure Certificate of Conformity is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:37:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26262

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

Identify as D3467-045

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT

1-Inspect finish

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

060330①

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

060331①

Job Completion



060330

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

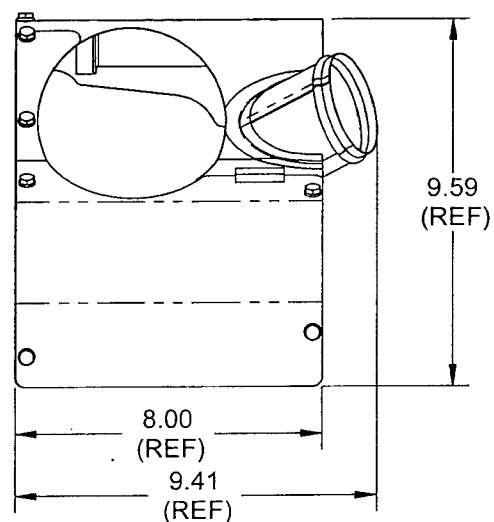
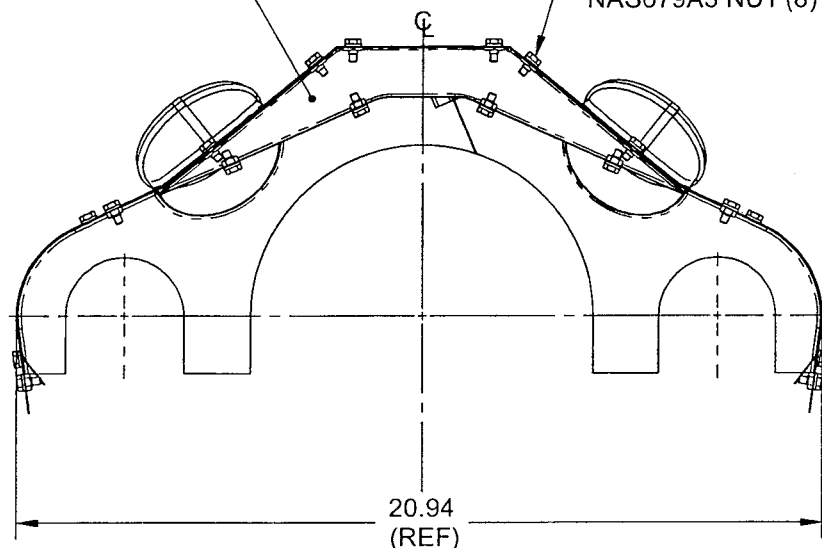
NOTE: Date & initial all entries

PRELIMINARY ISSUE

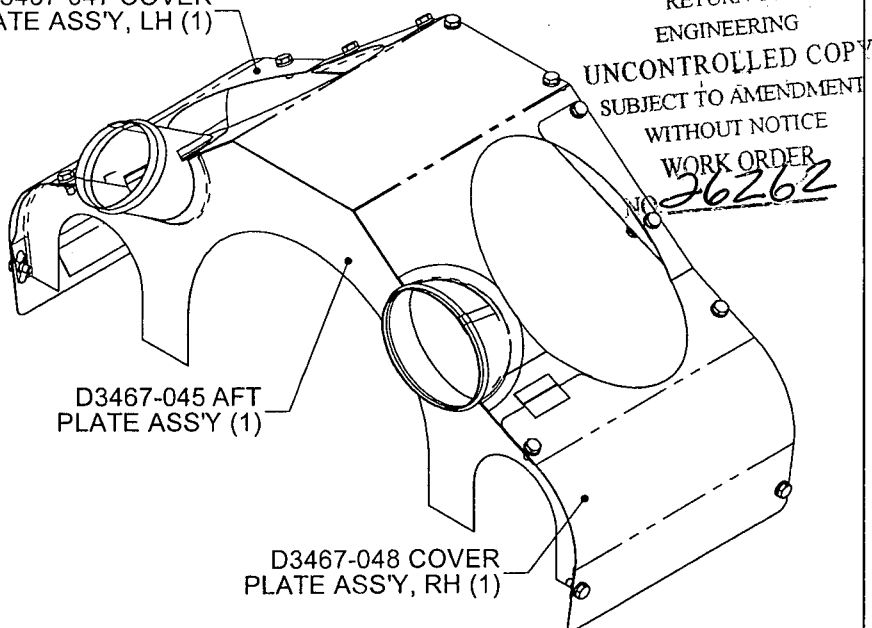
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:5
A	05.12.07	NEW ISSUE	

D3467-043 FWD
PLATE ASS'Y (1)

AN3-3A BOLT (18)
AN960-10 WASHER (18)
NAS679A3 NUT (8)



D3467-047 COVER
PLATE ASS'Y, LH (1)



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WITHOUT NOTICE
WORK ORDER
26262

D3467-041 SHROUD ASSEMBLY

NOTES:

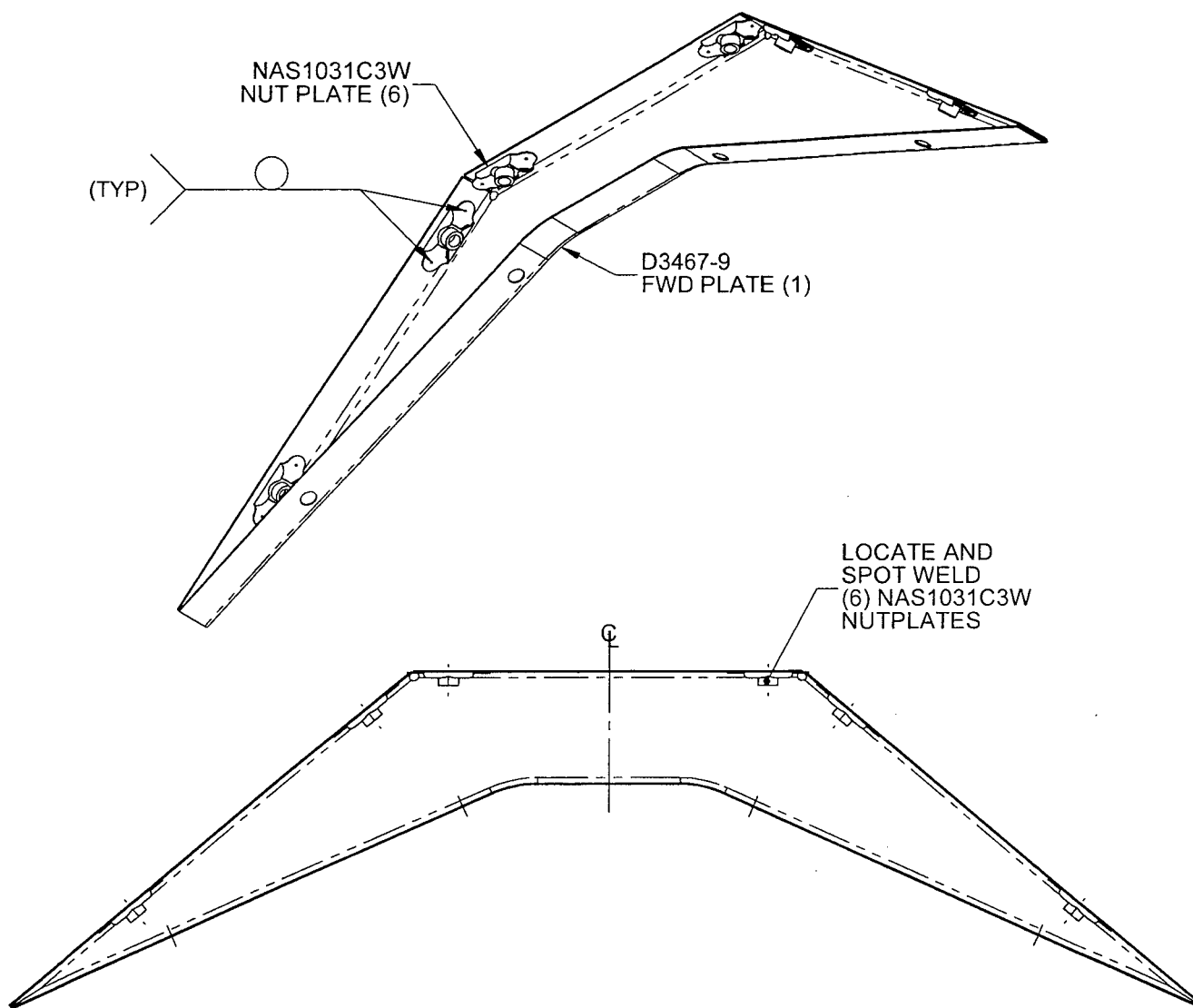
- 1) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: ELECTRO CHEMICALLY POLISH
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

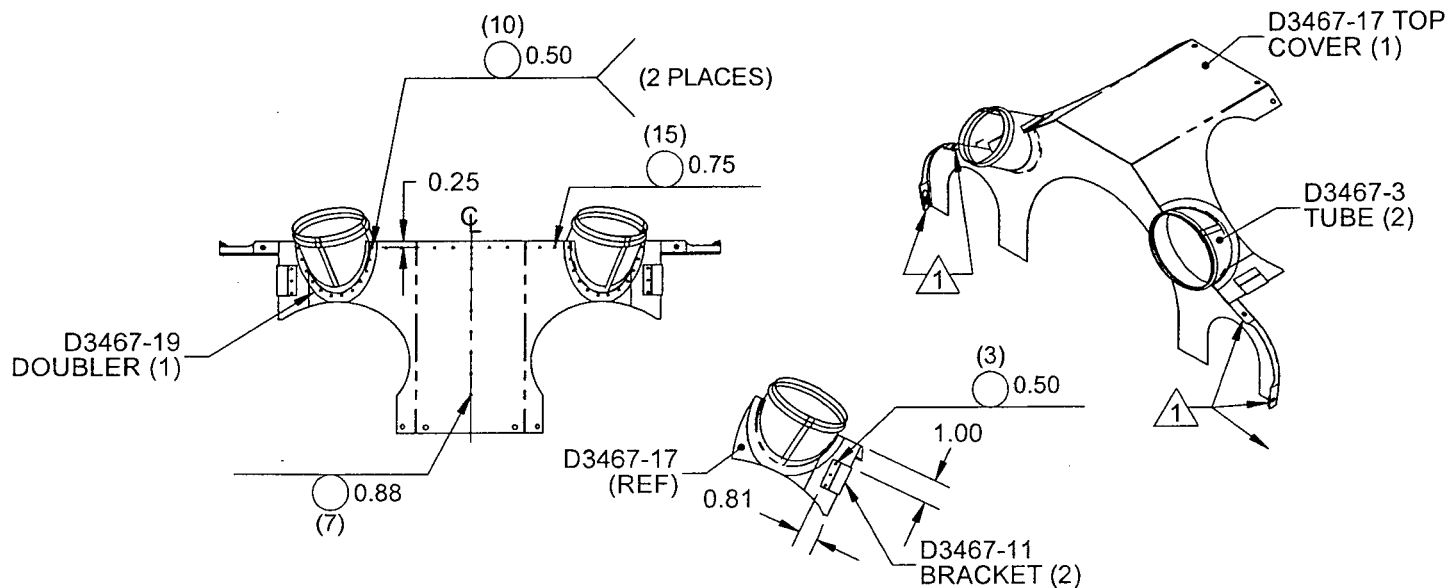
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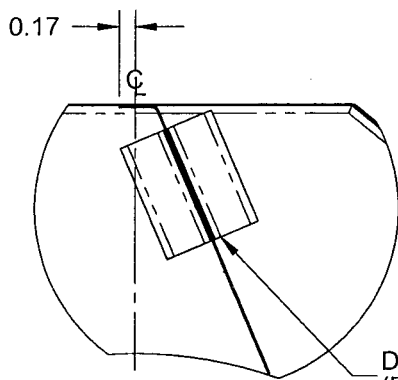
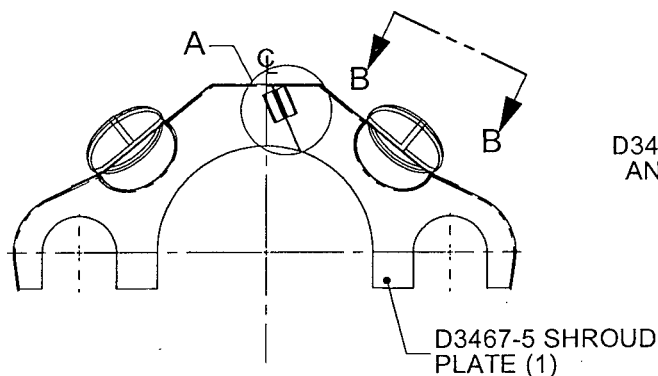
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:8



VIEW B-B: WELDING D3467-11
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)



DETAIL A
SCALE 1:2

D3467-045 AFT PLATE ASSEMBLY

NOTES:

- 1) LOCATE AND SPOT WELD NAS1031CW NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: ELECTRO-CHEMICALLY POLISH
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

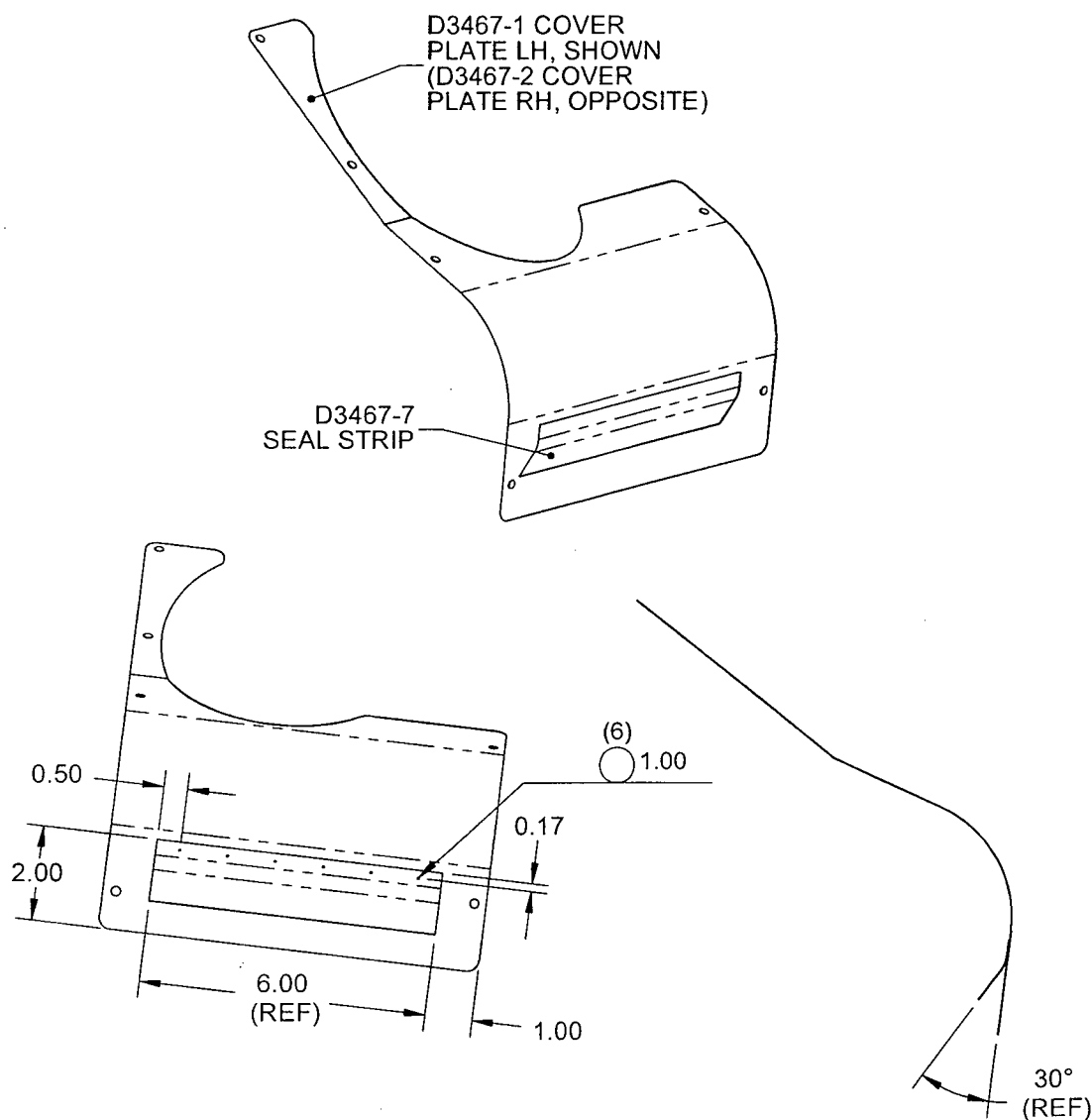
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



D3467-047 COVER PLATE ASS'Y LH, SHOWN
D3467-048 COVER PLATE ASS'Y RH, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISHED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

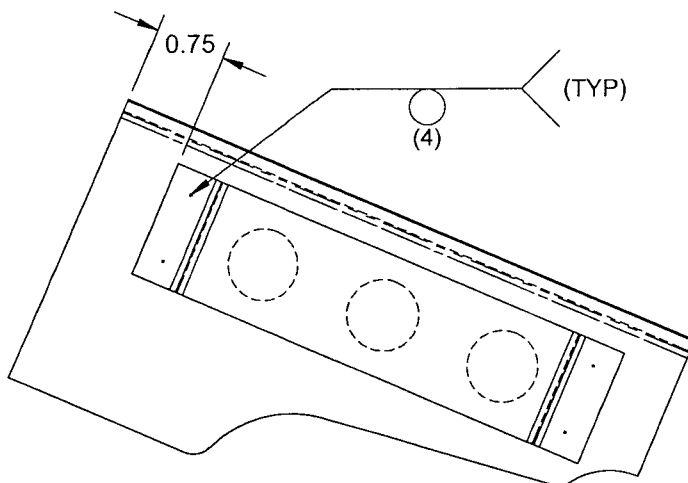
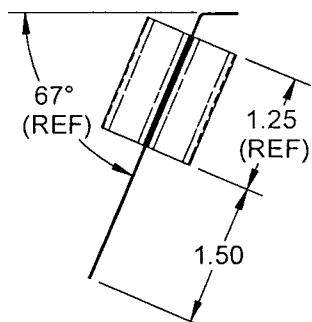
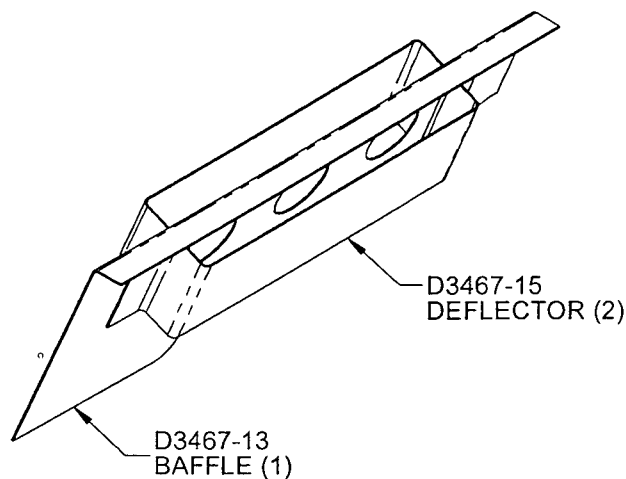
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

NOTES:

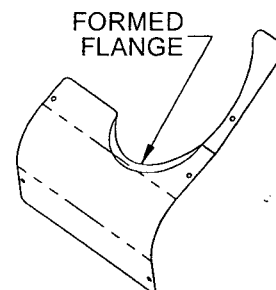
- 1) SPOT WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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11/11/1994



**D3467-1 LH COVER
PLATE ISOMETRIC VIEW,
D3467-2 RH COVER
PLATE (OPPOSITE)
SCALE 1:8**

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B F
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)

2) FINISH: ELECTRO CHEMICALLY POLISH

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

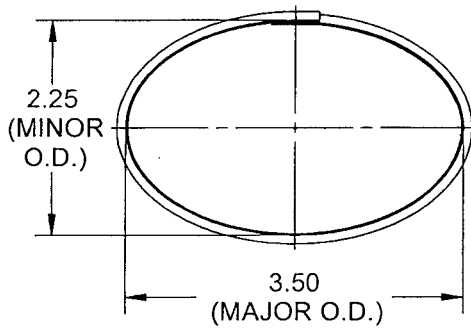
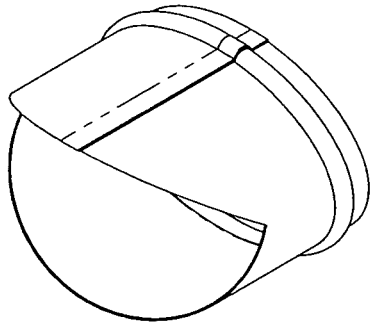
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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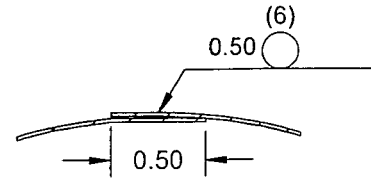
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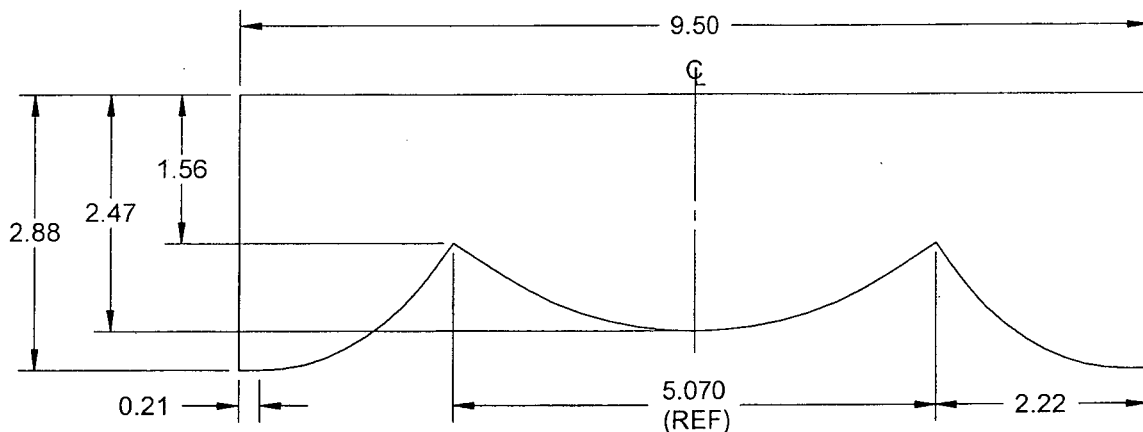
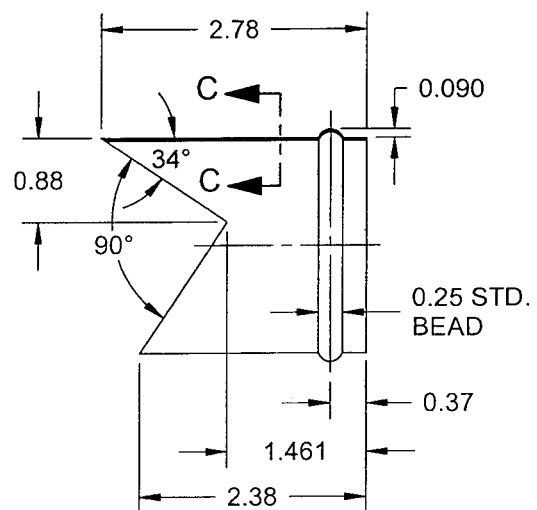
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



D3467-3 TUBE DETAIL



SECTION C-C
SCALE 1:1



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

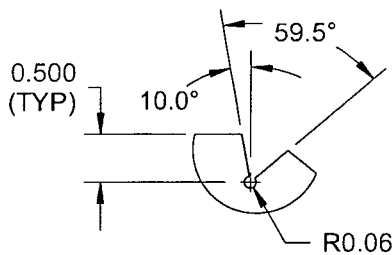
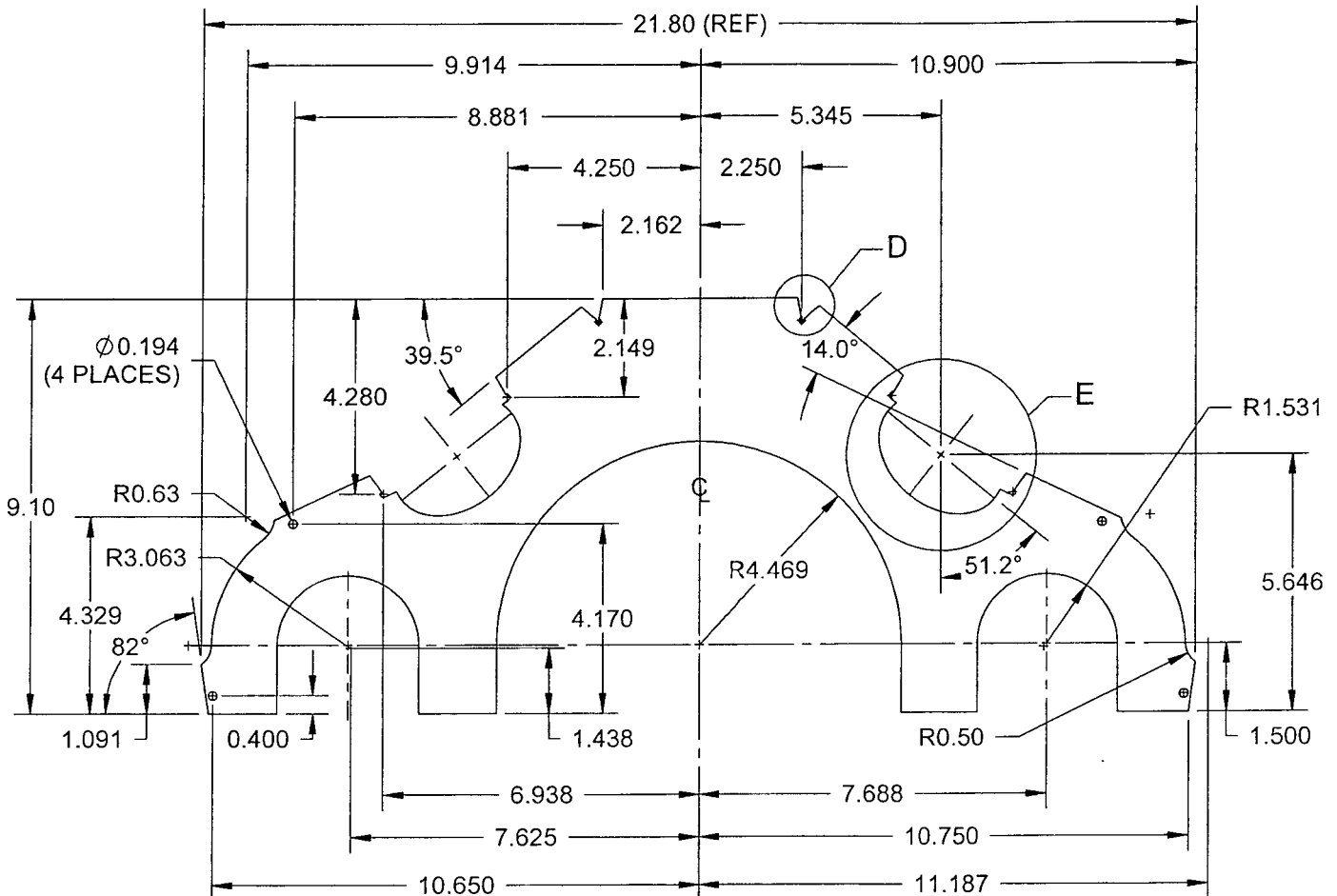
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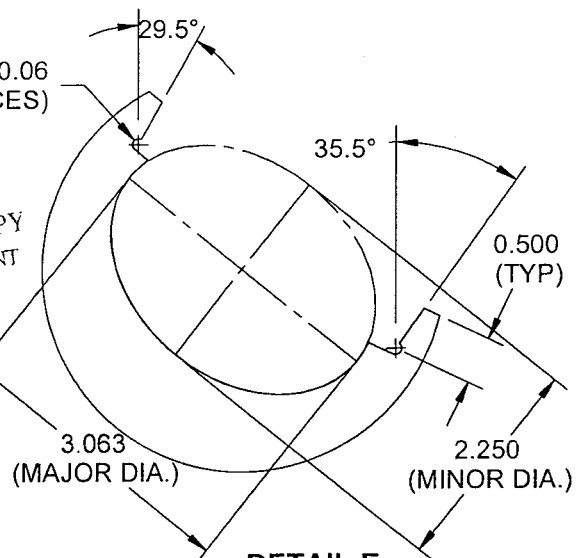
DETAIL D
SCALE 1:2

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NO. 26262

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



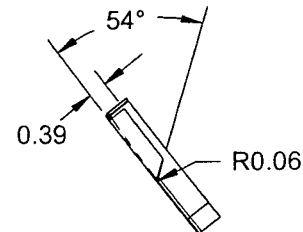
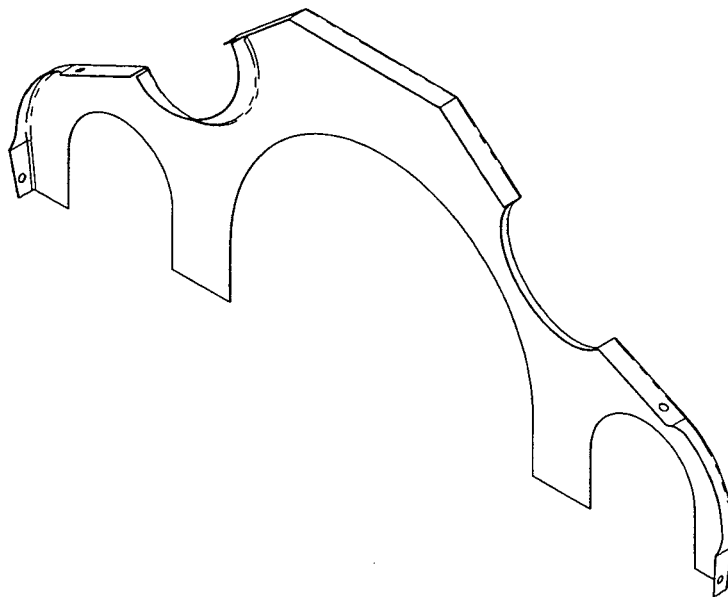
DETAIL E
SCALE 1:2

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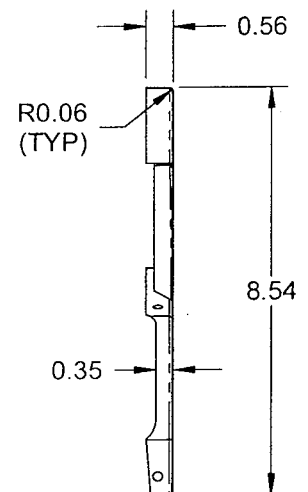
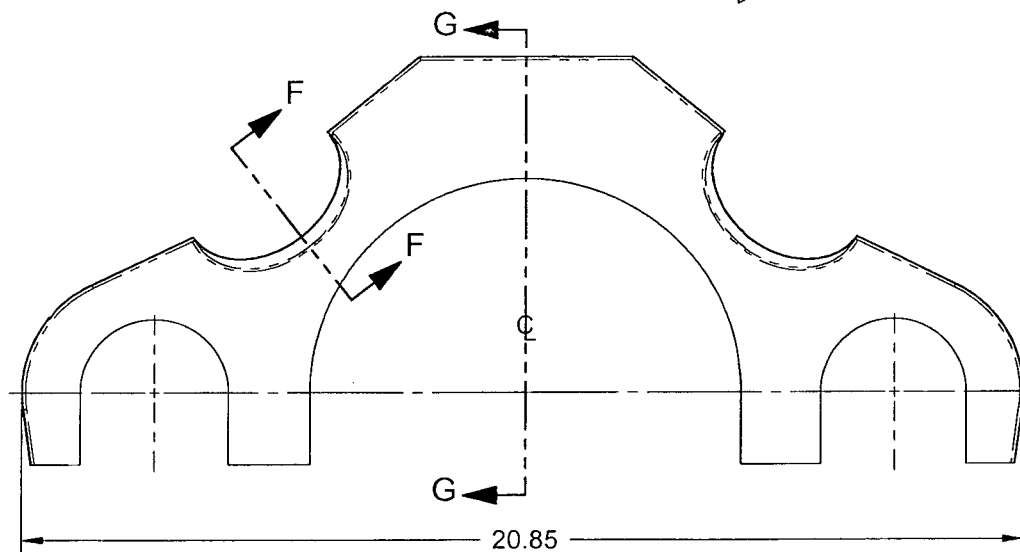
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



SECTION F-F



SECTION G-G

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

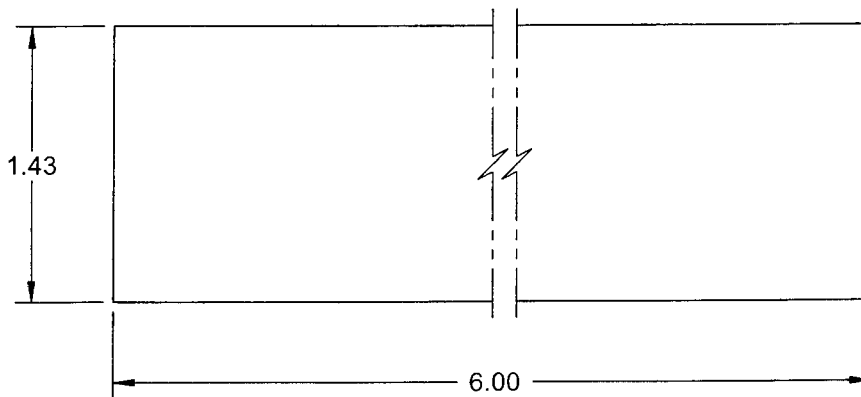
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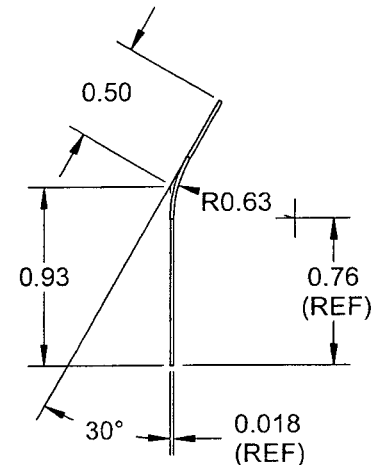
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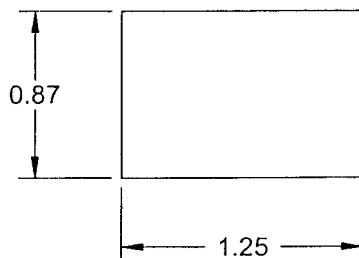
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:1



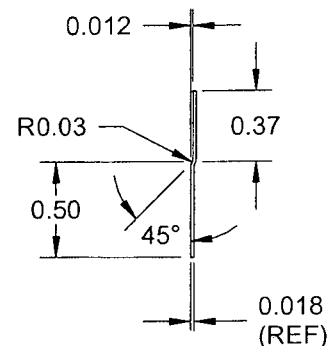
**D3467-7F SEAL STRIP
FLAT PATTERN**



**D3467-7 SEAL STRIP
BENDING DETAIL**



**D3467-11F BRACKET
FLAT PATTERN**



**D3467-11 BRACKET
JOGGLE DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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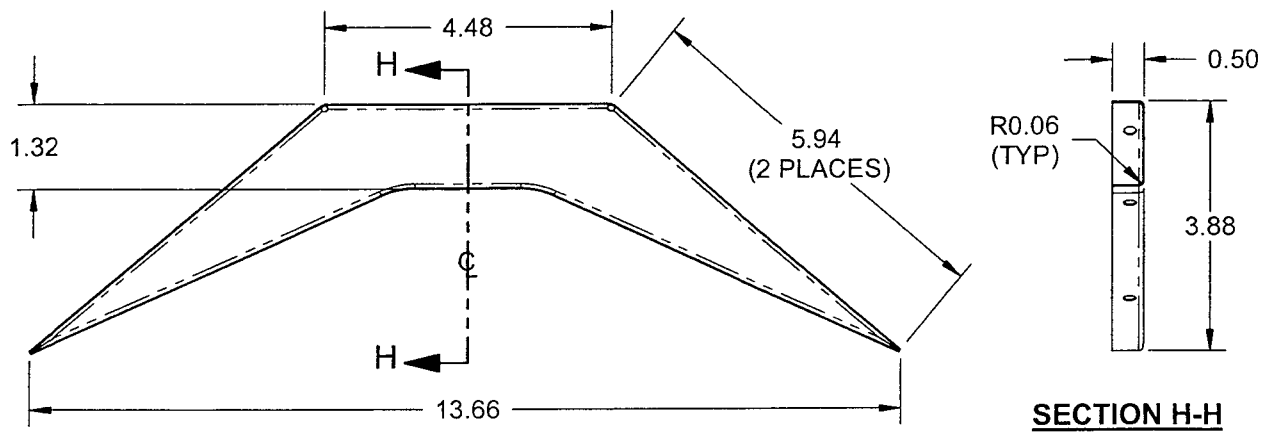
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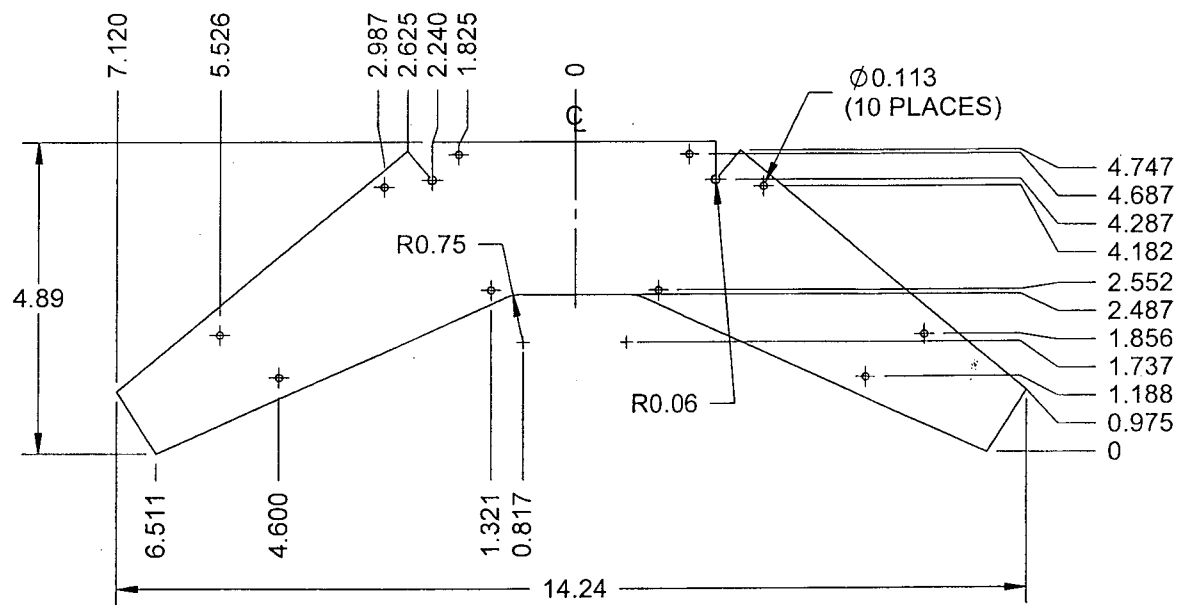
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CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 11 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:3



D3467-9 FWD PLATE BENDING DETAIL



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

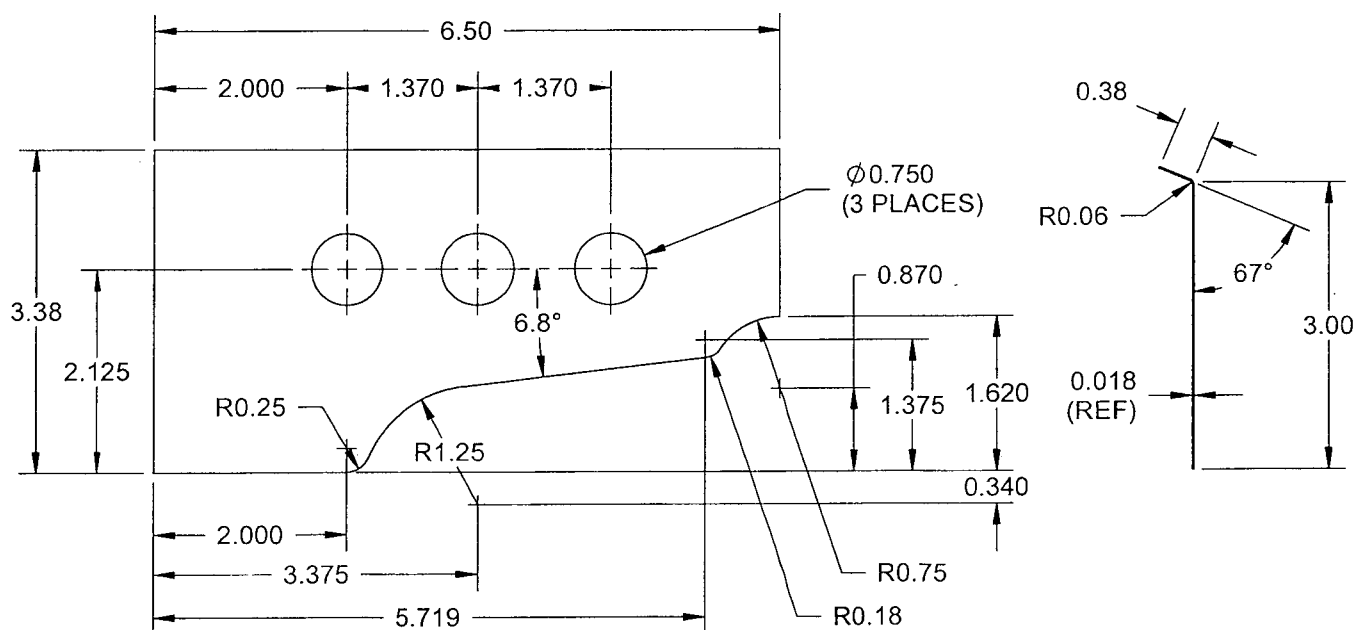
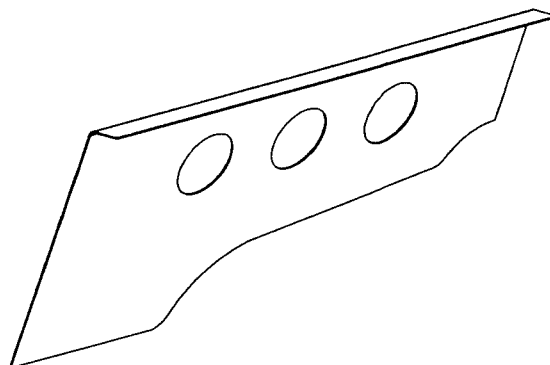
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**D3467-13F BAFFLE
FLAT PATTERN**

**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

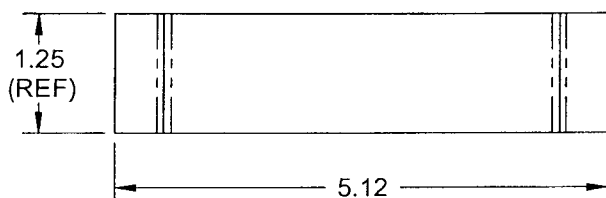
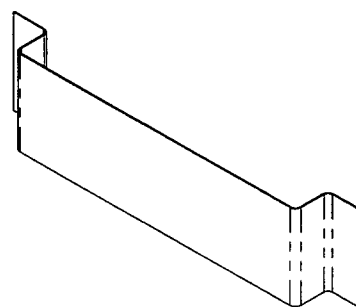
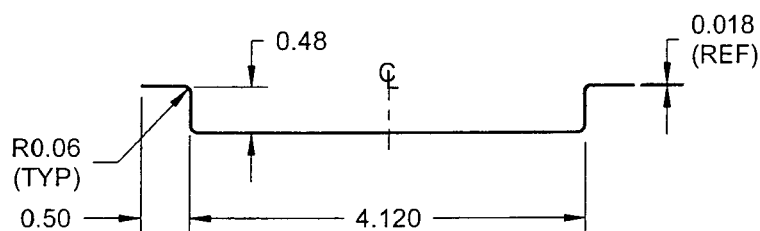
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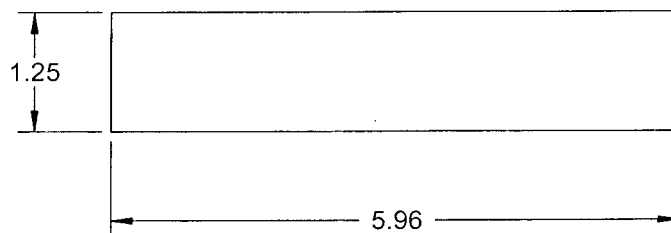
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D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

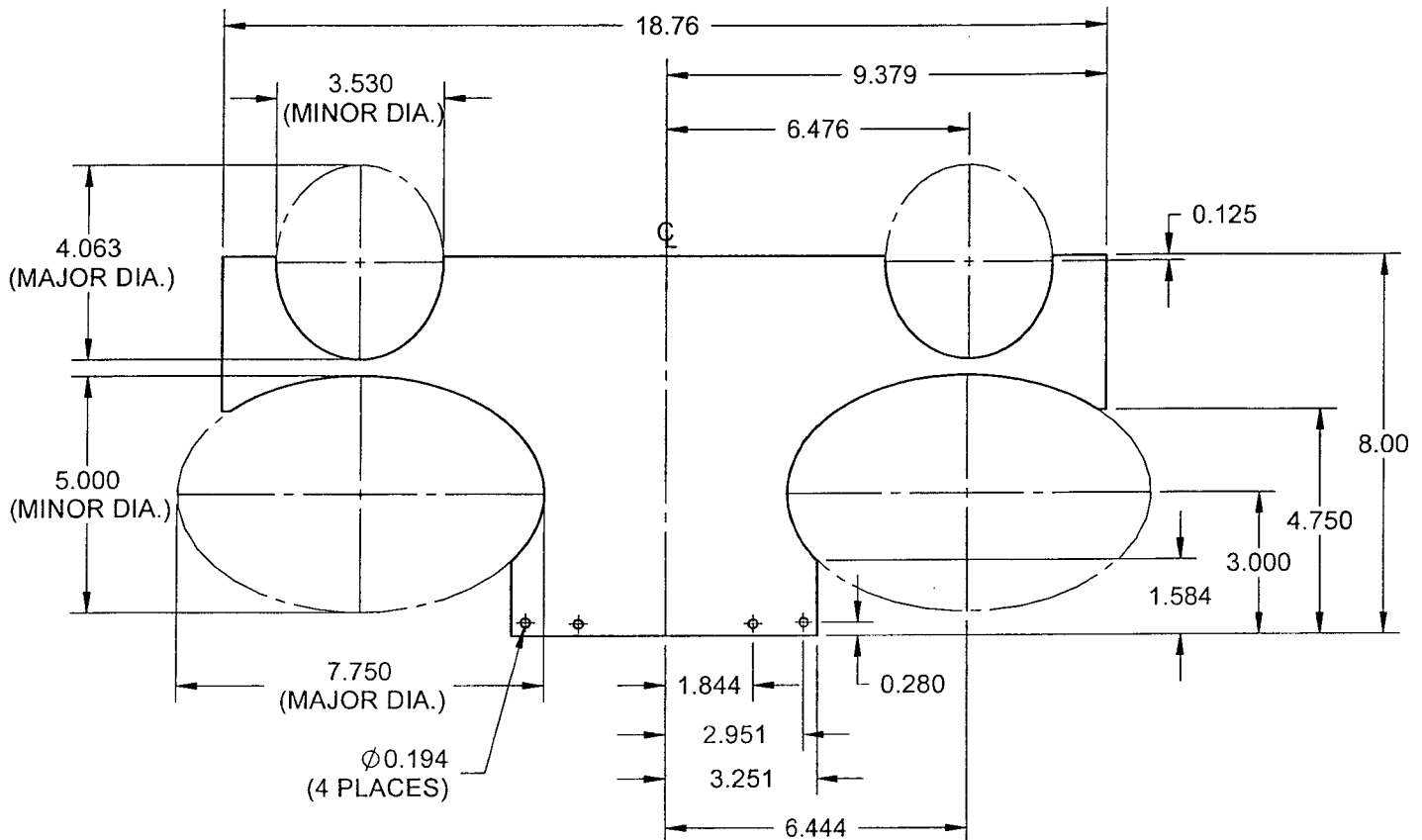
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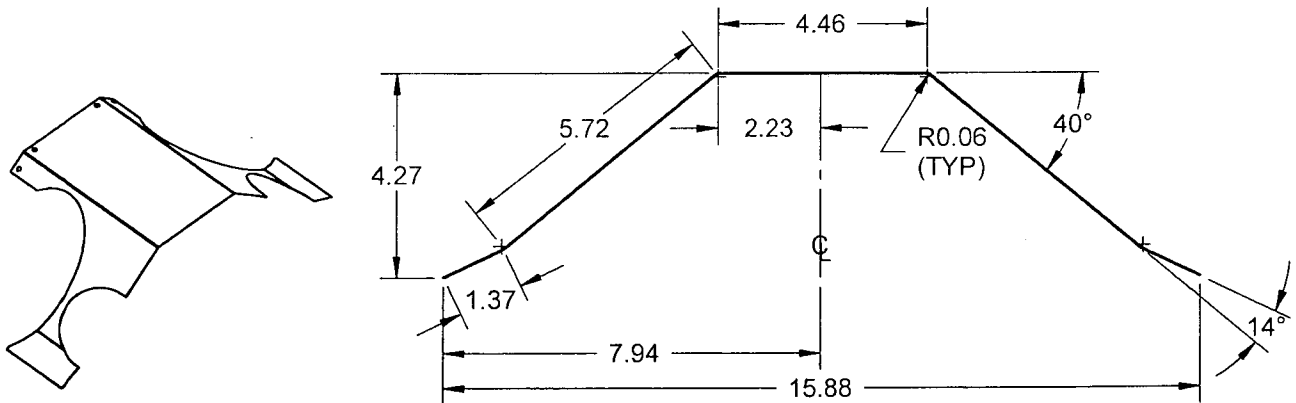
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D3467-17F TOP COVER FLAT PATTERN



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

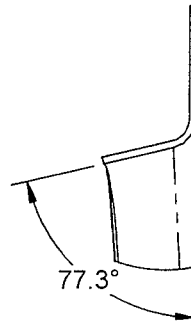
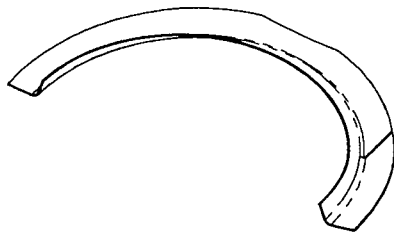
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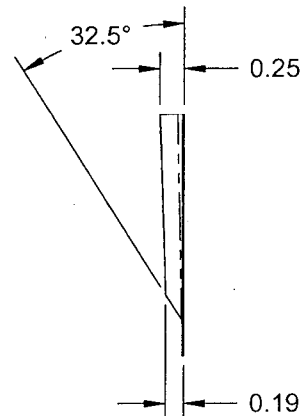
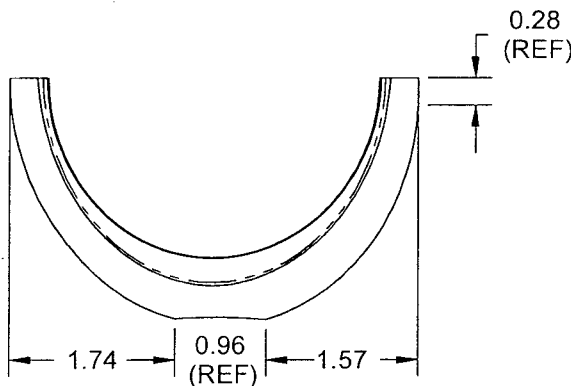
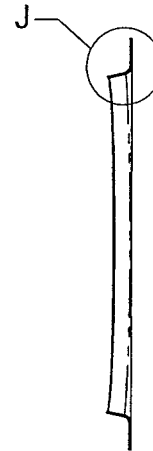
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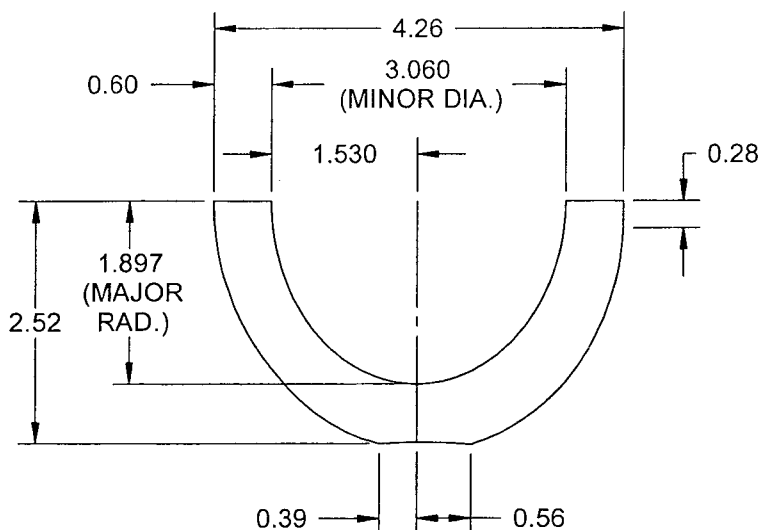
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



DETAIL J
SCALE 1:2



D3467-19 DOUBLER, LH SHOWN
D3467-20 DOUBLER, RH OPPOSITE



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D3467-19F FLAT PATTERN

NOTES:

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- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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